

Work Order ID 66822

Monday, February 28, 2011 11:24:16 AM



Page 1

Item ID: D2844-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Arm					
Start Date: 2/28/2011	Start Qty: 12.00		Cust Item ID:		
Required Date: 3/4/2011	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>110225</u>	Date: <u>11/02/25</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2844	Rev A

100	NC BRAKE	0.00							
	Brake NC	Memo	0.00						
	Brake NC	Form per Dwg D2844 using brake and bending Jig DT 8238-B <input type="checkbox"/> Debur							

12x

= 7m - 11/03/09

110	QC5- Inspect part completeness to step on W/O	0.00							
	QC	Memo	0.00						
	Quality Control								

11 03 10 12

120	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	Powdercoat	Memo	0.00						
	Powder Coating	START TIME: <u>1105</u> <input type="checkbox"/> OVEN TEMPERATURE: <u>1135</u>							
		FINISH TIME: <u>1100</u>							

12 11-3-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2844-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 2/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



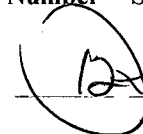
QC

Memo

0.00

Quality Control

11/3/10 SP



140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Ensure parts are still as per dwg D2844

8/6/03/11

4/2

150

Identify as per dwg & Stock Location: 266

0.00



Packaging

Memo

0.00

Packaging

11/3/11



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Page 3

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Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 2/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 12.00



Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/14 *[Signature]*
MF
11-03-14

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, February 28, 2011 11:24:22 AM

Page 1

Work Order ID: 66822

Parent Item: D2844-3

Parent Item Name: Arm



Start Date: 2/28/2011

Required Date: 3/4/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B 00.11.01 Removed P/O for Powder Coat - in house process EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035 		Purchased	No			100	f	110.3094	1.765	22.29474			
304 RD Tube .500 x .035W													

M-L 11/03/09

Location	Loc Qty	Loc Code
MAT	110.3094354	
115593	9.080387	
115990	34.4846264	
116720 ✓	66.744422	

22.29474

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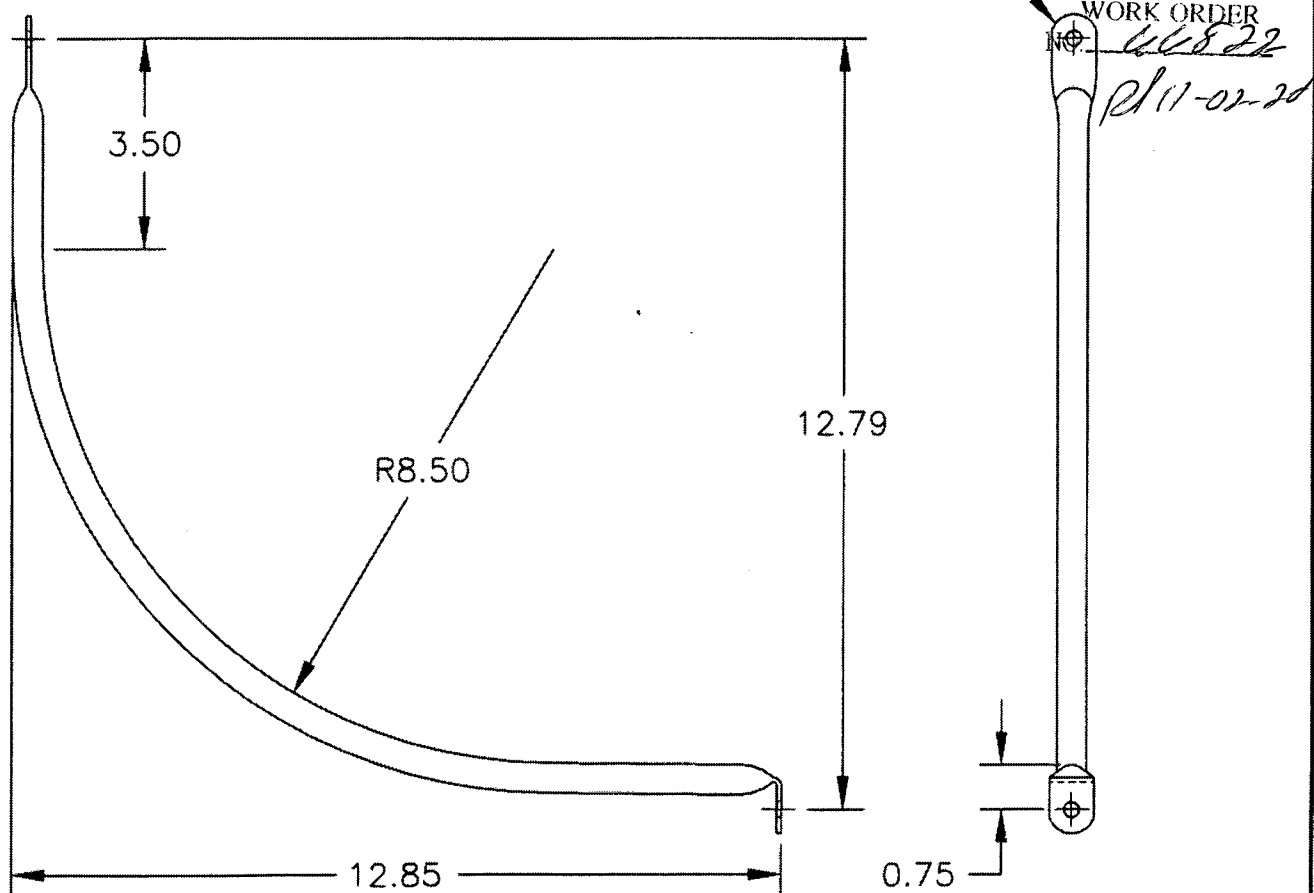
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>PAH</i>	APPROVED <i>JS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\varnothing 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

W/O:		WORK ORDER CHANGES					
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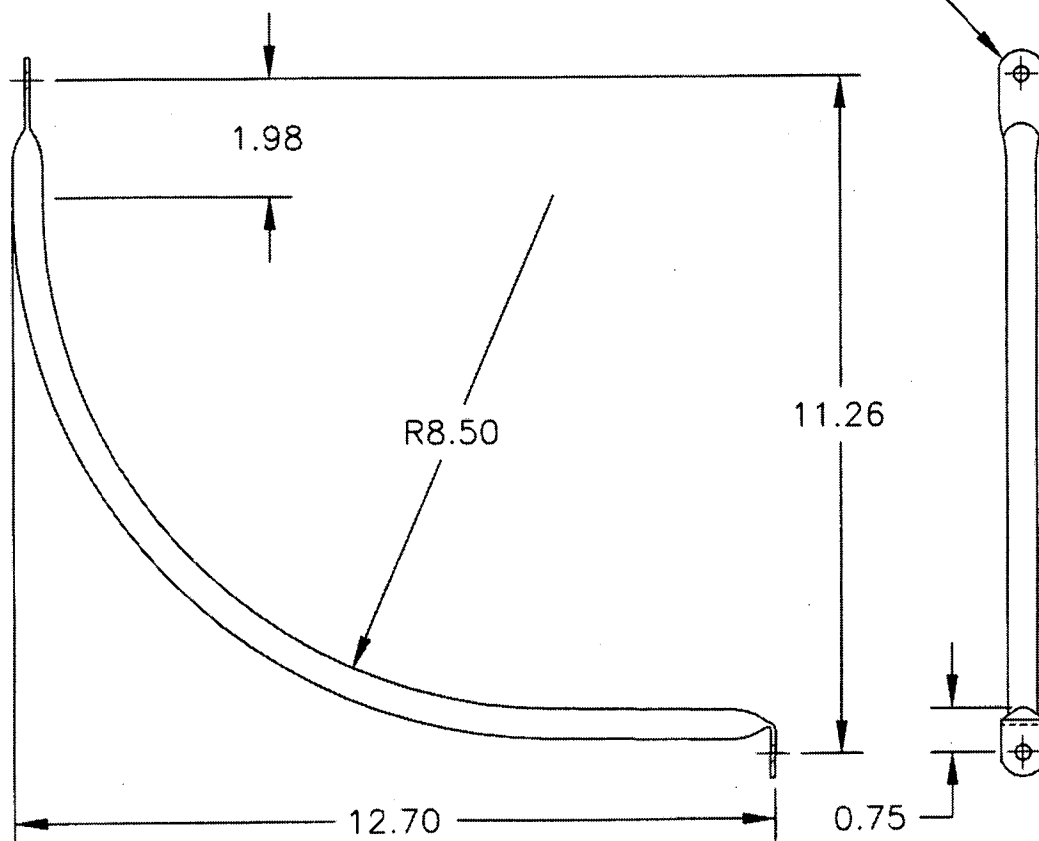


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED
19.11.11 KE

u1066822

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

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ENSURE TUBE IS SEAMLESS
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